Tuesday, 11/22/2005 4:58:32 PM Linda Lacelle User: Frocess Sheet : FWD MOUNTING LUG : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 24943 : 10453 Estimate Number : NIA : D26162 P.O. Number Part Number S.O. No. : NA : D2616 REV D3 : 11/22/2005 **Drawing Number** This Issue : N/A : NC Project Number Prsht Rev. : 11/22/2005 : MACHINED PARTS : D3 First Issue **Drawing Revision** : NIA : : 24748 Previous Ruñ Material **Due Date** : 12/2/2005 Qtv: 30 Um: Each Written By **Checked & Approved By** : Est Rev:C 00.06.22 Removed P/O for powder coat EC Comment Additional Product Job Number: Description: Seq. #: Machine Or Operation: M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0" 1.0 Comment: Qty.: 0.1749 f(s)/Unit Total: 5.2479 f(s) Material: 6061-T6 QQ-A-200/8 2" X 1" Bar Batch <u>/1/9059</u> BAND SAW BAND SAW 2.0 Comment: BAND SAW Cut blanks: 2.000" long +0.030" -0.000" HAAS1 HAAS CNC VERTICAL MACHINING #1 3.0 Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2616-2 & DWG D2616 2-Tumble & Deburr INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE MQ SECOND CHECK 5.0 QC8 Comment: SECOND CHECK

Dart Aerospace Ltd

W/O: ~	** **	WORK ORDER CHANGES										
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 05/12/03
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
		Description of NC		Corrective Action Section B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief-Eng	Initial Action Description Sign &		Chiếf Eng	QC Inspecto
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	esday, 11/22/2005 4:58:32 PM da Lacelle	Process Sheet	
Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name: FWD MOUNT	ING LUG
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Job Number:	: 24943	Part Number: D26162	
Job Number:			I
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Seq.#:	Machine Or Operation:	Description :	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	* 1980-19 278-28 517-20 5121 1885
Comm	ient: HAND FINISHING RESOURCE #1		1700H 0801 HO
	Chemical Conversion Coat as per QSI	005 4.1 <i>M</i>	05/11/29 30
7.0	POWDER COATING	POWDER COATING	37.7
Comme	ent: POWDER COATING Powder Coat Groy Sandtoy (Pef: 4.3.5)	: 6) an nor OCI 005 4 2	ı
	Powder Coat Grey Sandtex (Ref: 4.3.5 Note:Mask large hole	.0) as per QSI 005 4.3	11/29 26</td
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVE	RSION
			05:11:30 30
	ent: INSPECT POWDER COAT/CHEMICA		
9.0	D2611 i farka mia kiaki aan kal	Bearing	E MORRINA ARRIVA (OCC)
Comm	ent: Qty.: 1.0000 Each(s)/Unit Total:	30.0000 Each(s)	È 1000155 1834 1004
	Pick:	0010000 ====-1(-)	
	Qty Part Number Description	Batch	
10.0	1 D2611 Bearing	B24411	
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	1 (40) (C (40) (10) (10) (10)
		SB 05/11/20	
Comm	nent: SMALL & MEDIUM FAB RESOURCE 1		1801/81 2005/ 1000 1100 (1001
		'	
	1-Coat bearing in light oil		
	2-Press Bearing in D2616-2		
	2-F1633 Dealing in D2515 2	•	
	3-Stack as per Dwg D2616 using DT80)19	
	· - · · · · · · · · · · · · · · · · · ·		1 1
11.0	4- Touch up paint if required QC5	INSPECT WORK TO CURRENT STEP	02/11/30
11.0		MOFECT WORK TO CONNERT STEE	4 HATHIR ANNUL 11840 1841 1844 -
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Comm	ent: INSPECT WORK TO CURRENT STEP)	
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*	QA: N/C	DQA:	Date:	

NCR:		W	ORK OR	DER NON-CONFORM	IANCE (NCR) [t	
DATE	STEP	Description of NC Section A	Initial:	Corrective Action Secondary Action Description	Verification Section C	Approval Chief Eng	Approval QC Inspector	
ØS-11-30	9	Parts were noticed to be 0.8150.0.003 over MAX dimension of 0.8120. bearing can be installed they by hand, barely any press fit required.	Chief Eng	Plants Are Acceptable State booming in Bylands each side	Date 2	05-18-30	PARA	W-11-30
		hand, barrely any press Rot required.		************************************			6-5 2-1-4 3-	5
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NOTE: Date & initial all entries

Date: 🧇 Tuesday, 11/22/2005 4:58:32 PM User: Linda Lacelle **Process Sheet** Drawing Name: FWD MOUNTING LUG Customer: CU-DAR001 Dart Helicopters Services Job Number: 24943 Part Number: D26162 Job Number: Seq.#: Description: Machine Or Operation: PACKAGING 1 PACKAGING RESOURCE #1 12.0 Comment: PACKAGING RESOURCE #1 Identify and Stock 30 Location: 140 DOCUMENT CONTROL 13.0 Comment: DOCUMENT CONTROL Jui 05/10/05 Inspection Level 21

Job Completion



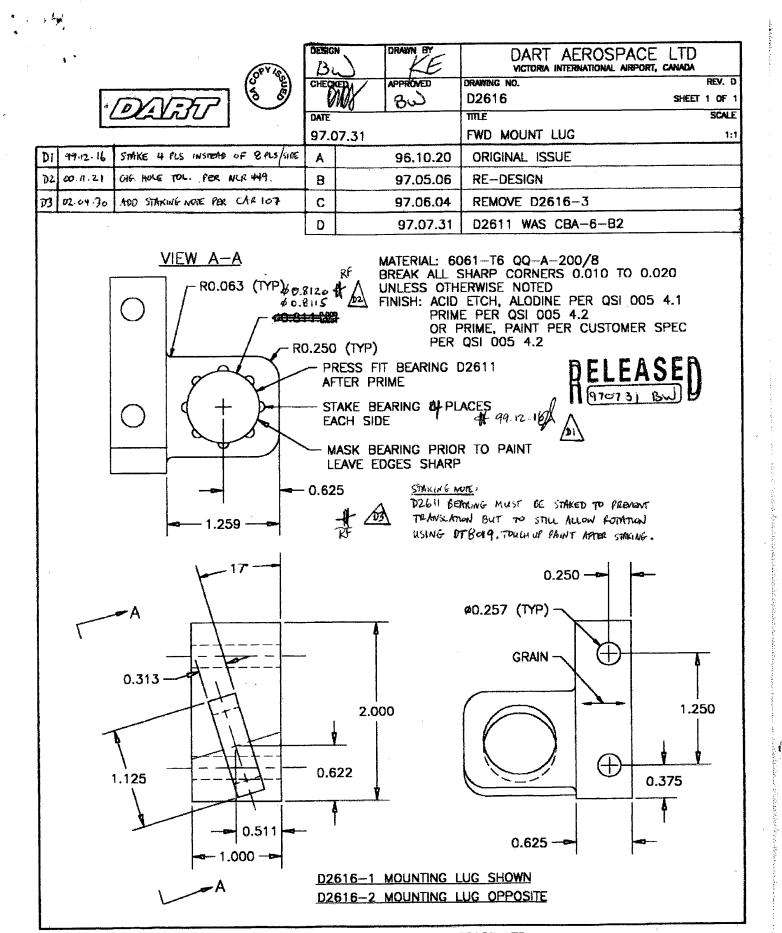
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Part No	:	PAR #: Fault Category:	NC	CR: Yes	No DG		Date: _ Date:	

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		Description of NC		Corrective Action Section	on B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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EMMI ALMOS	IACLLID				Work Order:	24943
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Inspection Dwg:	D2616 Rev:	D3				Page 1 of 1
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